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AUG 24 2018

D412-706-011
Job Sheet 182188



Part No: D412-706-011

Job Qty: 1 ea

Part Name: Fuel Purge Canister



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 19-20 IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD ver:EC IPP rev G 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23 as per IIN revA DD verified:EC IPP Rev:I 10.05.10 as per chg003 DD verified:EC IPP REV K 11.06.17 AS PER CHG 002 JLM VERIFIED:ec IPP Rev:L 12.12.07 as per IIN revB DD verified:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Stores/Pkg-1		DEC 04 2018 602
110	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-4		DEC 04 2018 9-806
120	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC4		69 DAS 69
130	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		DAS 9-80 69
135	DC	1 pcs	8/31/18	8/31/18	0.00	0.00	DC		21 DEC 20 2018
140	QC21-FG	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21		DAS 21 9-80 DEC 20 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-5A	Bolt	4 Ea (4 ea)	90-Start up Operation	5119258
AN814-8D	Plug	1 Ea (1 ea)	90-Start up Operation	FM1348573
AN815-6D	Union M Flare	2 Ea (2 ea)	90-Start up Operation	5107191
AN815-8D	Union-M-Flare	1 Ea (1 ea)	90-Start up Operation	5124239
AN833-6D	Elbow, Bulkhead-M-Flare	2 Ea (2 ea)	90-Start up Operation	5093625
AN833-8D	Elbow	1 pcs (1 ea)	90-Start up Operation	FM126475
AN924-6D	Nut	4 Ea (4 ea)	90-Start up Operation	5095433
AN924-8D	Nut	1 pcs (1 ea)	90-Start up Operation	FM126400
AN938-6D	Tee	1 Ea (1 ea)	90-Start up Operation	5089115
D2001-4	Valve Assembly 1/4 Inch	1 Ea (1 ea)	90-Start up Operation	5113072
D3262-043	Canister Assembly	1 Ea (1 ea)	90-Start up Operation	5131402
D3264-1	Bracket	2 Ea (2 ea)	90-Start up Operation	5110352
D3297-1-0098	Hose Assembly	1 Ea (1 ea)	90-Start up Operation	5087024
D3297-1-0121	Hose Assembly	1 Ea (1 ea)	90-Start up Operation	5087025
D3297-3-0210	Hose Assembly 21.00"	1 Ea (1 ea)	90-Start up Operation	5087026
D3298-005	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5097458
D3298-007	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5092479
D3299-3	Fitting	1 Ea (1 ea)	90-Start up Operation	5094764
D3299-5	Fitting	1 Ea (1 ea)	90-Start up Operation	5134877
D3299-7	Fitting	1 Ea (1 ea)	90-Start up Operation	5109125
D3301-1	Placard	1 Ea (1 ea)	90-Start up Operation	5033942
D3301-3	Placard	1 Ea (1 ea)	90-Start up Operation	5092727

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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D3302-1	Doubler	1 Ea (1 ea)	90-Start up Operation	5104295
D3302-3	Doubler	1 Ea (1 ea)	90-Start up Operation	5104307
D3329-1	Bushing	2 Ea (2 ea)	90-Start up Operation	5157303
D4054-001	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5092573
D4054-003	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5082617
D4054-009	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5082222
MS21042L3	Nut	4 Ea (4 ea)	90-Start up Operation	5094592
MS21919-WDG9	Clamp	2 Ea (2 ea)	90-Start up Operation	5100066
MS21920-42	Clamp	2 Ea (2 ea)	90-Start up Operation	5108571
MS29512-06	O-Ring	7 pcs (7 ea)	90-Start up Operation	5081296
MS29512-08	O-Ring	3 pcs (3 ea)	90-Start up Operation	5006915
MS35489-16	Grommet	1 Ea (1 ea)	90-Start up Operation	5121255
NAS1149D0332J	Washer	4 Ea (4 ea)	90-Start up Operation	5100406
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5107142
NAS1149D0963J	Washer	2 Ea (2 ea)	90-Start up Operation	5052386

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-5A	4	414	0
	AN814-8D	1	3	0
	AN815-6D	2	18	0
	AN815-8D	1	11	0
	AN833-6D	2	15	0
	AN833-8D	1	4	0
	AN924-6D	4	29	0
	AN924-8D	1	7	0
	AN938-6D	1	2	0
	D2001-4	1	3	0
	D3262-043	1	0	0
	D3264-1	2	3	0
	D3297-1-0098	1	3	0
	D3297-1-0121	1	6	0
	D3297-3-0210	1	6	0
	D3298-005	1	3	0
	D3298-007	1	3	0
	D3299-3	1	11	0
	D3299-5	1	15	0
	D3299-7	1	12	0
	D3301-1	1	11	0
	D3301-3	1	9	0
	D3302-1	1	3	0
	D3302-3	1	2	0
	D3329-1	2	13	0
	D4054-001	1	2	0
	D4054-003	1	2	0
	D4054-009	1	2	0
	MS21042L3	4	3,988	0
	MS21919-WDG9	2	75	0
	MS21920-42	2	6	0
	MS29512-06	7	101	0
	MS29512-08	3	47	0
	MS35489-16	1	26	0
	NAS1149D0332J	4	2,751	0
	NAS1149D0363J	8	1,847	0
	NAS1149D0963J	2	500	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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